

# Work Order ID 58450

May 7, 2010 10:08:18 AM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 07/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3571

Rev A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 2.90 " long

B.F. 10/05/17

20 4

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A □2-Deburr per dwg D3571

cmk 10/05/18

20 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

cmk 10/05/18

20 0

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Page 2

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 10/05/18

20

0

Memo

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Hand 10/05/19

20

0

Memo

0.00

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112580

=> Hand 10/05/20

20

0

Memo

0.00

START TIME: 10:00 AM FINISH TIME: 10:30 AM OVEN TEMPERATURE: 320 F

# Work Order ID 58450

May 7, 2010 10:08:18 AM



Page 3

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 07/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 10-5-25

170

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

10-5-26 SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31 MF 10-5-27

# Picklist Print

May 7, 2010 10:08:22 AM

Page 1

Work Order ID: 58450



Parent Item: D3571-1



Parent Item Name: Guide

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: IPP Rev:A New Issue 07-02-01 JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	12.0000	0.241			



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT

12

114415

12

~~4.5033~~  
5.025

S.F. 10/05/17

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	58456
<b>Description:</b> Guide		<b>Part Number:</b>	D3571-1
<b>Inspection Dwg:</b> D3571 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.698	✓			
Ø1.00 Depth 100	+/-0.010	.993x.100	✓			
2.75	+/-0.030	2.753	✓			
1.38	+/-0.030	1.371	✓			
1.25	+/-0.030	1.255	✓			
0.63	+/-0.010	.627	✓			
0.031 chamfer	+/-0.010	.029	✓			
Ø0.500	+0.006/-0.001	.502	✓			
Ø0.201	+0.005/-0.001	Ø.203	✓			
R0.25	+/-0.030	R.250	✓			
0.260	+0.000/-0.010	.260	✓			
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.385x100°	✓			
0.125	+/-0.010	.125	✓			
2.250	+/-0.010	2.242	✓			
0.250	+/-0.010	.253	✓			
0.188	+/-0.010	.186	✓			
0.063 chamfer	+/-0.010	.068	✓			

<b>Measured by:</b>	amf
<b>Date:</b>	10/05/18

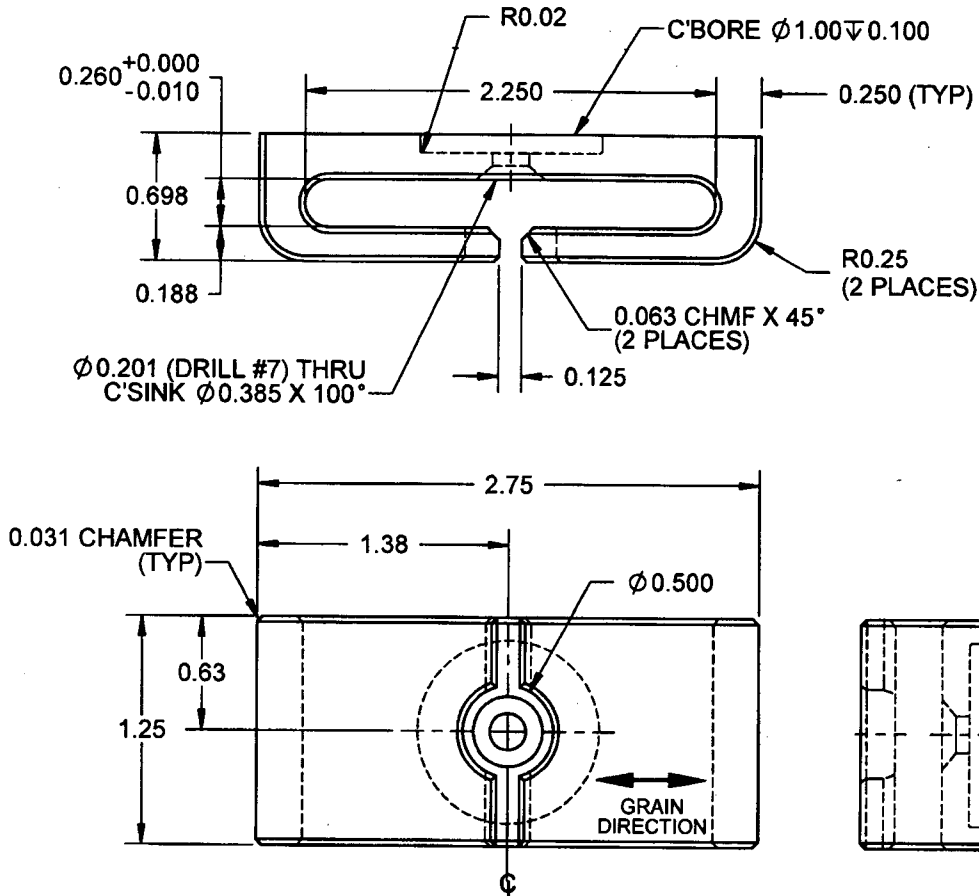
<b>Audited by:</b>	B.A
<b>Date:</b>	10/05/18

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

**DART**

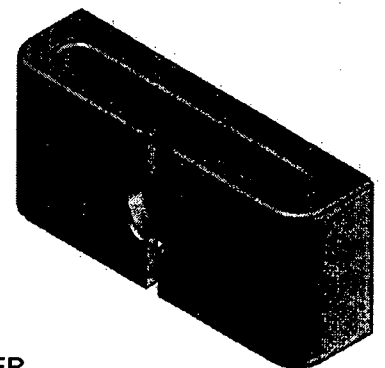
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3571</b>	REV. A SHEET 1 OF 2
DATE <b>07.01.29</b>	TITLE <b>GUIDE</b> SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

**RELEASED**07.04.12 *[Signature]*

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WORK ORDER  
NO. 58450  
*810-5-07*

**D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\varnothing$

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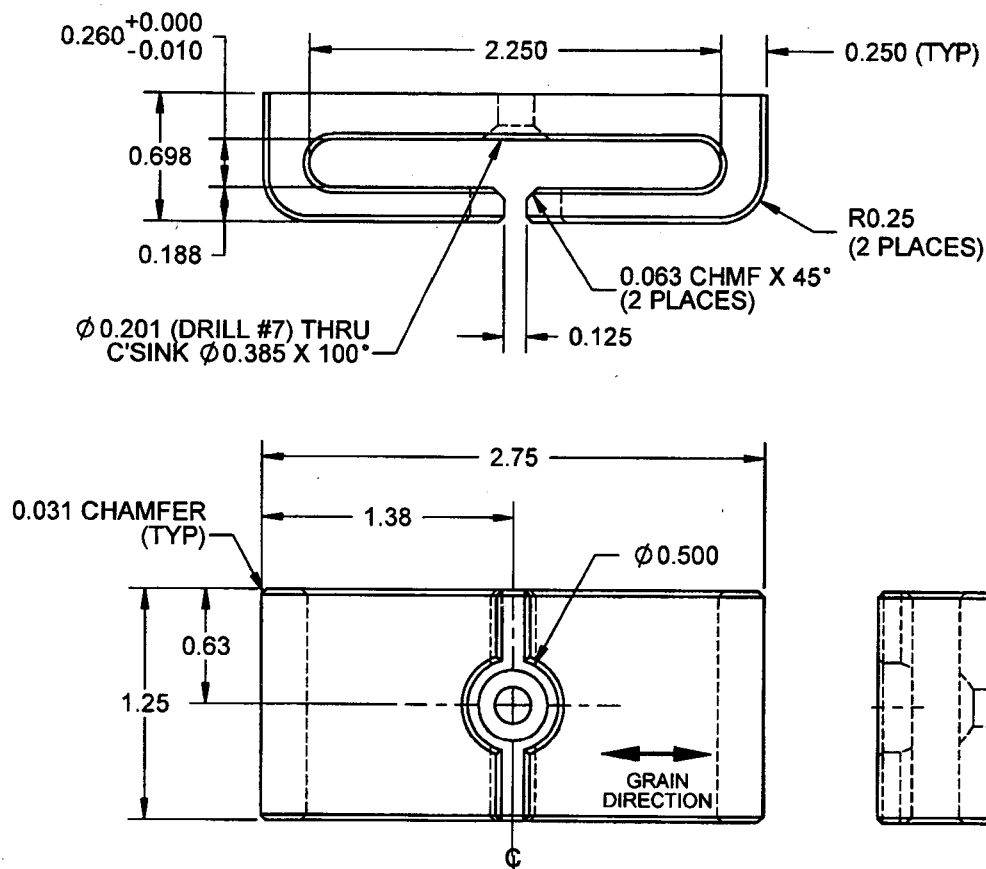
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**DART**

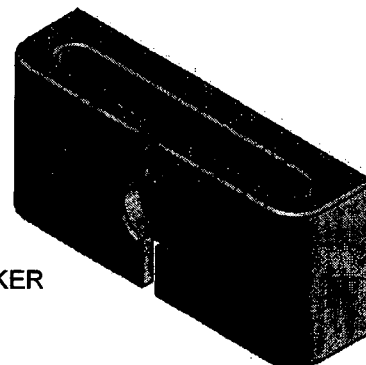
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CHECKED <i>PH</i>	APPROVED <i>MA</i>	DRAWING NO. <b>D3571</b>	REV. A
DATE <b>07.01.29</b>	TITLE <b>GUIDE</b>	SHEET 2 OF 2	
		SCALE 1:1	

**RELEASED**

07.01.12

**D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\phi$

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